

Date: Thursday, 2/14/2008 2:21:45 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SUPPORT BRACKET
Job Number	: 37459		
Estimate Number	: 10260		
P.O. Number	:	Part Number	: D23623
This Issue	: 2/14/2008 S.O. No. :	Drawing Number	: D2362 REV E1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : MACHINED PARTS	Drawing Revision	: E1
Previous Run	: 35328	Material	:
Written By	:	Due Date	: 3/5/2008
Checked & Approved By	:	Qty:	12 Um: Each
Comment	: Est: G 00.05.18 Added inspection level 8 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2265	Step Support Casting
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Step Support

Pick:

Qty	Part Number	Description	Batch
1	D2265	Step Support	29807

Batch

29807

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: Machine per folio D2362-3

JL 08/02/19

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: Inspect Level 2

JL 08/02/19

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

JL 08.02.19

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

JL 08/02/19

6.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Gloss White (Ref 4.3.5.1) as per Dart QSI 005 4.3

JL 08.02.20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/02/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/14/2008 2:21:45 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT BRACKET

Job Number: 37459

Part Number: D23623

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



11X

Comment: INSPECT POWDER COAT

M-1

08/02/20

8.0

D23971

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-1

Rubber

336/17

SB 08/02/22

11

9.0

D23973

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-3

Rubber

336/18

SB 08/02/22

11

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond rubber D2397-1 followed by D2397-3 using contact cement
as per Dwg D2362

Batch

1102565

08/02/26

11

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 08/02/26

11

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

478

8/12/27

11X

13.0

QC21

FINAL INSPECTION/W/O RELEASE



11

Comment: FINAL INSPECTION/W/O RELEASE

08/02/27

Job Completion



2008/2/27

11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART



RELEASED
98.12.14 KE

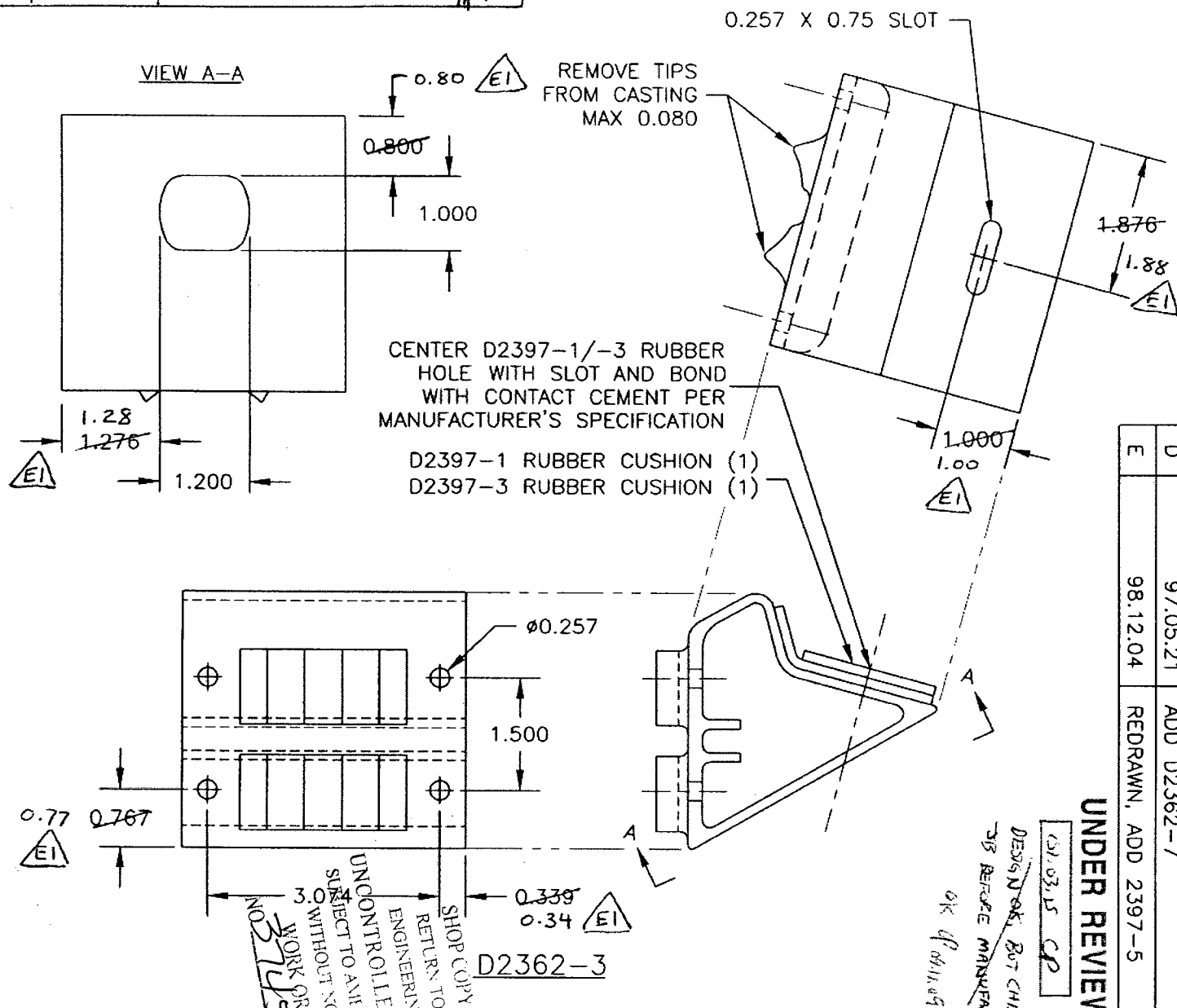
DESIGN	DRAWN BY	DART AEROSPACE LTD
BW	<i>CP</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	<i>CP</i>	D2362
DATE	TITLE	REV. E
98.12.04	STEP SUPPORT BRACKET	SHEET 1 OF 3
		SCALE 1:2
A	95.02.15	NEW ISSUE
B	95.03.22	CHANGED RUBBER TO D2397
C	96.01.22	ADD D2362-5
D	97.05.21	ADD D2362-7
E	98.12.04	REDRAWN, ADD 2397-5

UNDER REVIEW

07.03.15 CP

DESIGN OK, BUT CHECK WITH
38 BEFORE MANUFACTURE
OK 07.04.04

EI 03.10.07 TOLERANCE CHANGE ~~RT~~



NOTES:
MAKE FROM D2265
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING RUBBER IN PLACE
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED	KE	APPROVED	KE	HAWKESBURY, ONTARIO, CANADA
DATE	98.12.04	DRAWING NO.	D2362	REV. E
		TITLE	STEP SUPPORT BRACKET	SHEET 2 OF 3
		SCALE	1:2	

RELEASED
98.12.14
UNDER REVIEW
KE

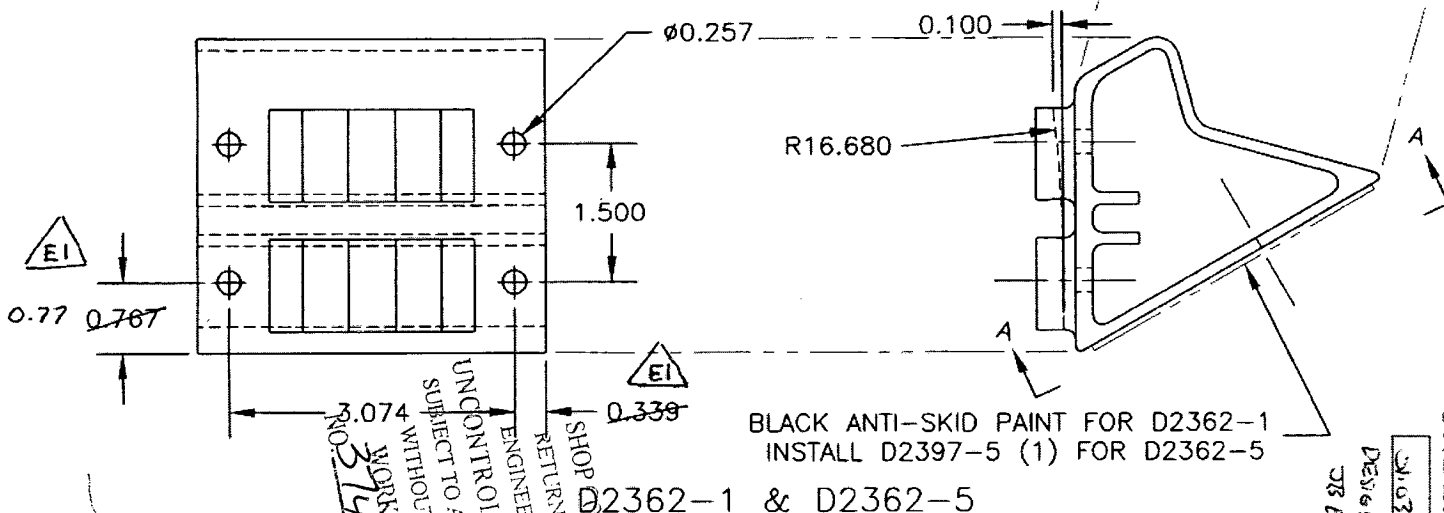
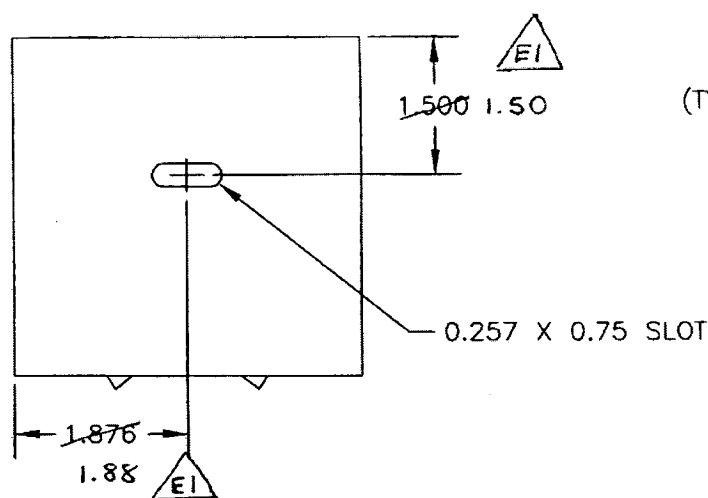
3103.05 CP

DESIGN OK, BUT CHECK BY
JTB BEFORE MANUFACTURE
OK 09.1.09

MACHINE TO
R1.100
(TYP 2 PLACES)

REMOVE TIPS
FROM CASTING
MAX 0.080

VIEW A-A



BLACK ANTI-SKID PAINT FOR D2362-1
INSTALL D2397-5 (1) FOR D2362-5

D2362-1 & D2362-5

NOTES:

- MAKE FROM D2265
- D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION
- FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
- BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37469
SHOP COPY
RETURN TO
ENGINEERING



DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED	KE	APPROVED	KE	HAWKESBURY, ONTARIO, CANADA
DATE	98.12.04	DRAWING NO.	D2362	REV. E
		TITLE	STEP SUPPORT BRACKET	SHEET 3 OF 3
		SCALE	1:2	

UNDER REVIEW

31.03.15 CP

DESIGN OK BUT CHECK WITH
JTS BEFORE MANUFACTURE

RELEASED
98.12.14 KE

D2362-041 (SHOWN)
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PIAINT PER QSI 005 4.4 AFTER
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)
MAKE FROM D2265 CASTING. DRILL D2265 AS
SHOWN IN D2362-041 ASSEMBLY

NOTES:
TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

REMOVE TIPS
FROM CASTING
MAX 0.080

BLACK ANTI-SKID PAINT
D2244-3.75

WELD PER DART 1/8
QSI 004

OK CP 04/11/04

D2362-7

